



Dart Aerospace Ltd.
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RBE105-14101W12
Job Sheet 194405



Part No: RBE105-14101W12

Job Qty: 1 pcs

Part Name: Mounting Device



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/1/19

Job Tracking No:

Due Date: 6/10/19

Created By: Marie Lajeunesse

Type: SOLD

Description: *order 14896*

Note: DWG RBE105-14101W12 Rev.1 IPP Rev. A 18.10.22 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Small Fab - 1	1 pcs	6/10/19		0.00	0.00	Small Fab - 1		
							Small Fab - 2		<i>MCL</i>
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	Small Fab - 2 - B4B	1 pcs	6/10/19		0.00	0.20	Small Fab - 1 - B4B		
							Small Fab - 2 - B4B		<i>MCL</i>
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		
							Small Fab - 5 - B4B		
							Small Fab - 6 - B4B		
							Small Fab - 7 - B4B		
120	QC 5	1 pcs	6/10/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		



Container No: S194396



Part: RBE105-14101W12

Job No: 194405

Serial No/Batch: S194396

Revision: B

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
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CANADA
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Email: sales@dartaero.com
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Date: 06/27/19

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130 Packaging 3-1 - Stock - B4B 1 pcs

6/10/19

0.00 0.00

Packaging 3 - 1 - B4B

Packaging 3 - 2 - B4B

Packaging 3 - 3 - B4B

Packaging 3 - 4 - B4B

Packaging 3 - 5 - B4B

Packaging 3 - 6 - B4B

Packaging 3 - 7 - B4B

Packaging 3 - 8 - B4B

Packaging 3 - 9 - B4B

Packaging 3 - 10 - B4B

Packaging 3 - 11 - B4B

Packaging 3 - 12 - B4B

Packaging 3 - 13 - B4B

Packaging 3 - 14 - B4B

Packaging 3 - 15 - B4B

Packaging 3 - 16 - B4B

Packaging 3 - 17 - B4B

Packaging 3 - 18 - B4B

Packaging 3 - 19 - B4B

Packaging 3 - 20 - B4B

Packaging 3 - 21 - B4B

Packaging 3 - 22 - B4B

Packaging 3 - 23 - B4B

Packaging 3 - 24 - B4B

Packaging 3 - 25 - B4B

Packaging 3 - 26 - B4B

Packaging 3 - 27 - B4B

Packaging 3 - 28 - B4B

Packaging 3 - 29 - B4B

Packaging 3 - 30 - B4B

Packaging 3 - 31 - B4B

Packaging 3 - 32 - B4B

Packaging 3 - 33 - B4B

Packaging 3 - 34 - B4B

Packaging 3 - 35 - B4B

Packaging 3 - 36 - B4B

MLC

140 QC 21 - FG

1 pcs

6/10/19

0.00 0.00

QC 21 - FG - 21

QC 21 - FG - 70

QC 21 - SA - 53

DAS

JUN 28 2019

70

9-89

RB001A

Part Op 110 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case
 Descriptions: APP-1500-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue placard RBE105-14101W12-11 to RBE105-14101W12-15 foam as per DWG. 6-Glue foam to case and pack case as per DWG..

120 - (QC5- Inspect part completeness to step on W/O)

130 - (Identify as per dwg & Stock Location:_____)

140 - (QC21- Final Inspection - Work Order Release)

Job BOM

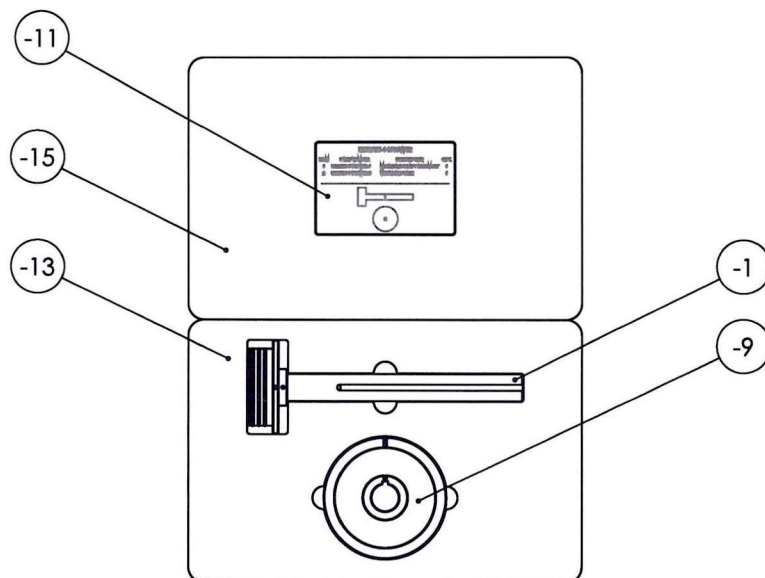
Part / Item	Component Name	Quantity	Operation	Container
97524A032	Sealing Blind Rivet	4 Ea (4 ea)	90-Small Fab - 1	5163934
APP-1500-E	Case	1 Ea (1 ea)	90-Small Fab - 1	5184259
RB41011	Dart Tooling Placard, Aluminum	1 pcs (1 ea)	90-Small Fab - 1	5021040
RBE105-14101W12-11	Contents Placard	1 pcs (1 ea)	90-Small Fab - 1	5137898
RBE105-14101W12-13	Bottom Foam use in case APP-1500-E	1 Ea (1 ea)	90-Small Fab - 1	5184255
RBE105-14101W12-15	Top Foam use in case APP-1500-E	1 Ea (1 ea)	90-Small Fab - 1	5184258
RBE105-14101W12-1-80	Mounting Shaft Assembly	1 (1 ea)	110-Small Fab - 2 - B4B	5103806
RBE105-14101W12-9 80	Mounting Base	1 (1 ea)	110-Small Fab - 2 - B4B	5193808

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Small Fab - 1	97524A032	4	305	0
	APP-1500-E	1	0	0
	RB41011	1	338	0
	RBE105-14101W12-11	1	2	0
	RBE105-14101W12-13	1	0	0
	RBE105-14101W12-15	1	0	0
	RBE105-14101W12-1	1	0	0
110-Small Fab - 2 - B4B	RBE105-14101W12-1	1	0	0
	RBE105-14101W12-9	1	0	0
Part Specifications				
Specifications could not be found.				

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION.	2/5/2016	DPD	JAG



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WITHOUT NOTICE
WORK ORDER
NO. 194405ML5
190501

NOTE:
REF. EUROCOPTER T/N: 105-14101W12.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		-1	1	MOUNTING SHAFT ASSEMBLY			2
	1		-3		MOUNTING SHAFT BASE	6061		3
	1		-5		MOUNTING SHAFT ROD	6061		4
	1		-7		KEY	S.S.	1/4 X 1/4 (MCMaster-CARR #92530A136) MODIFIED	5
			-9	1	MOUNTING BASE	6061		6
			-11	1	CONTENTS PLACARD	PLASTIC		7
		B/O	-13	1	BOTTOM FOAM	Y20, BLACK	4.25 X 11.40 X 17.00 (I.R. SPECIALTY)	8
		B/O	-15	1	TOP FOAM	Y20, BLACK	1.79 X 11.40 X 17.00 (I.R. SPECIALTY)	9
	1	B/O	-17		SPRING PIN	STEEL	Ø1/8 X 1-1/2 (MCMaster-CARR #98296A887)	2
	3	B/O	-19		O-RING	VITON	Ø.070 X Ø3.239 I.D. X Ø3.379 O.D. (MCMaster-CARR #9464K421)	2
		B/O	-21	1	CASE	PLASTIC	PELICAN #APP-1500-E	N/S
		B/O		1	DART PLACARD	ALUMINUM	RB41011	N/S
	ASSY -1							

DART AEROSPACE	
MOUNTING DEVICE	
DWG NO. RBE105-14101W12	REV 1
MAT'L HEAT TREAT FINISH SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° X ± .1 SURFACES = 125/ .015 x 45° OR .015R	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: DUERFELDT	USED ON MODEL
CHECKED: CLOUGH	EC145
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
SCALE 1:8	DATE 12/22/2015
SHEET 1 OF 9	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					